

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SKIDTUBE ASSEMBLY
<b>Job Number</b>	: 29598		
<b>Estimate Number</b>	: 10022		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D205634011
<b>This Issue</b>	: 11/21/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b>	: N/A
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b>	: N/A
<b>Previous Run</b>	: 29597	<b>Material</b>	: N/A
<b>Written By</b>	:	<b>Due Date</b>	: 12/10/2006
<b>Checked &amp; Approved By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

## Job Number:

Seq. #:	Machine Or Operation:	Description :
1	1000	1000
2	1000	1000
3	1000	1000
4	1000	1000
5	1000	1000
6	1000	1000
7	1000	1000
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9	1000	1000
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97	1000	1000
98	1000	1000
99	1000	1000
100	1000	1000

1.0 DC DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

2.0	29598A	SKID TUBE ASSEMBLY
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**Comment:** Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 29598 A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment: PACKAGING RESOURCE #1**

## Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1 K10003 Saddle Kit B29615  
1 D205-634-041 Skidtube Assembly(ref) 29598 A

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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**Comment:** INSPECT 100% KITS FOR COMPLETENESS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DS Date: 07/01/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:13:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 29598

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: \_\_\_\_\_

REV G

06/12/27

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/02

Job Completion



06/12/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 29598A  
 Estimate Number : 10023  
 P.O. Number : N/A Part Number : D205634041  
 This Issue : 11/21/2006 S.O. No. : N/A Drawing Number : D2580 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 29597A Material : N/A  
 Due Date : 12/10/2006 Qty: 1 Um: Each  
 Written By : [Signature]  
 Checked & Approved By : [Signature]  
 Comment : Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 Est Rev. O 06.02.28 Added paperwork EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634 CHG001

N/A

2.0 D25001190 Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion B25858

[Signature]  
 m-h 06/11/240

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2596 205 Web 29722

[Signature]  
 Jb - 06/11/30

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

[Signature]  
 Jb

06/11/29 ①

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

[Signature]  
 Jb 06/11/29 ①

3-Acid etch and Alodine tube per QSI 005 4.1

[Signature]  
 m-h 06/11/24 ①

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

[Signature]  
 Jb 06/11/29 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29598A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

*Prm* JB 06/11/29 (1)

6-Countersink holes as per Dwg D2580 without cutting fluid

*Prm* JB 06/11/29 (1)

7-Deburr and blow out all chips from inside of tube

*Prm* JB 06/11/29 (1)

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	m 102	660

Sikaflex expire date: 07/02/01

Start Time: 345 Date: 06/11/29

Fin Time: 9AM Date: 6-12-4

*Prm* JB 06/11/29 (1)

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP 6-12-4

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

*Prm* M.R 06/12/04 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step B 23060	BE 06-12-05

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



Date: Tuesday, 11/21/2006 1:14:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29598A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B-29489 BE 06-12-05

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

BE 06-12-05

2-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill.

BE 06-12-05

A/R

Aluminum Rod

m101446

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

JB/Pmc 06-12-60

4-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web. Debur

Pmc 06-12-60

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

Pmc 06-12-60

6-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Debur

Pmc 06-12-60

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Debur

Pmc 06-12-60

8-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m101446

BE 06-12-05

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/12/06 01

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/06 01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29598A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M 102391



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

m-h/a.m

06/12/14

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

06 12 18 11

15.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2577-1	Wearplate

Batch

28063

16.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2577-3	Wearplate

Batch

29326

17.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D2577-5	Wearplate

Batch

19824

18.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description
44	ALS7-1032-130	Inserts

Batch

18964

FL

06 12 18 11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29598A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	102217

20.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	102832

21.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: 280141

22.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: 27168

23.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 26351

24.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 15205

FC 06 12 18 @ ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PP Date: 07/01/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 1:14:07 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 29598A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: 102217

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

102673

Sikaflex expire date: 0207

FC

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

FC

3-Inspect for foreign object per QSI 024

FC

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R

Sikaflex-291

102673

Sikaflex expire date: 0207

FC

06 12 18

①

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

m103004

Batch:

a.m.

06/12/19

①X

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

N/A

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/00

U 06.12.29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_





QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



RELEASED  
98/09/17 DS

DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2580	
DATE 98.08.26				REV. C SHEET 1 OF 2	
		TITLE 205 SKIDTUBE ASSEMBLY		SCALE NTS	
A	96.09.16	NEW ISSUE			
B	96.12.02	AS MANUFACTURED			
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097			

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

400.08.28  
100.08.28

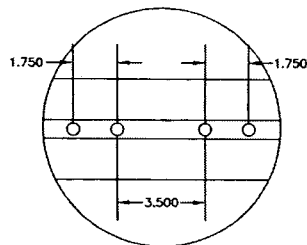
EFFECTIVE	DEOS
DEO 9124 # 171/185	DEO 9183 2003 30

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
  - 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
  - 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
  - 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
  - 6) WELDING TO BE DONE PER DART QSI 004.
  - 7) FINISH:
    - ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
    - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
    - BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
  - 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).
- SHOP COPY

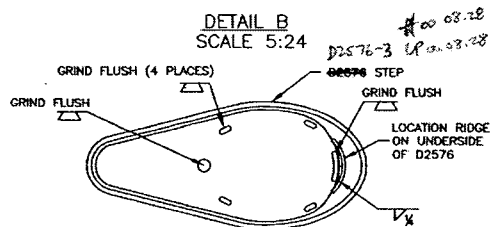
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UNCONFIRMED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29598A

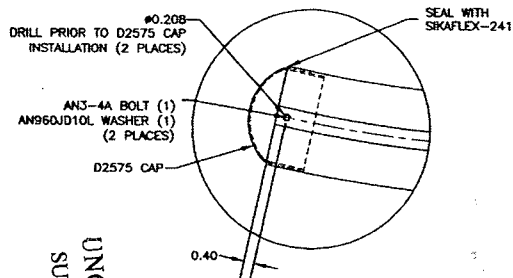
DETAIL A  
SCALE 5:24



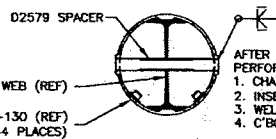
DETAIL B  
SCALE 5:24



DETAIL C  
SCALE 5:24

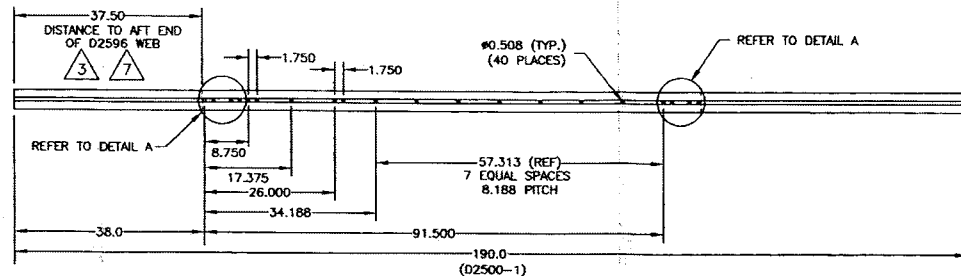


SECTION D-D  
SCALE 5:24

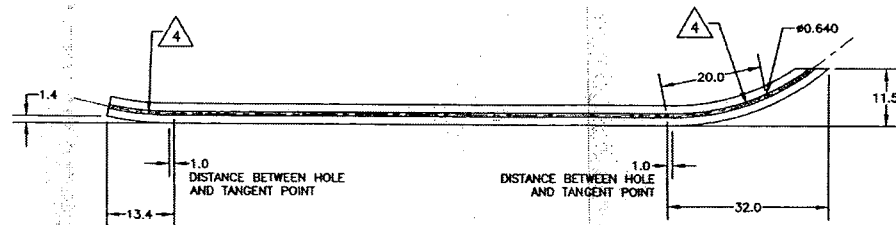


AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

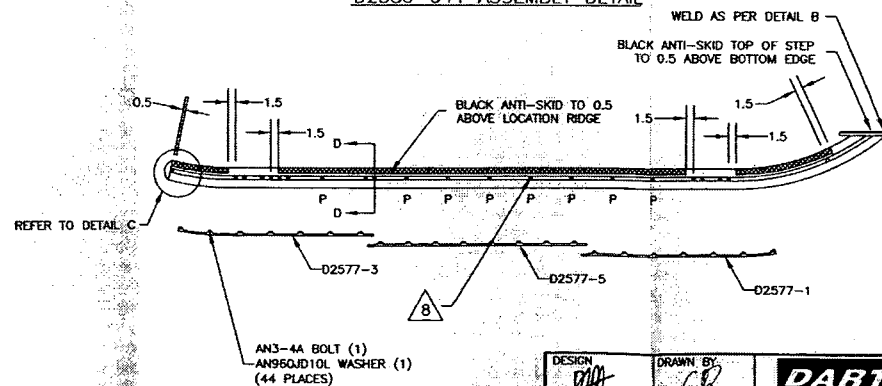
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL

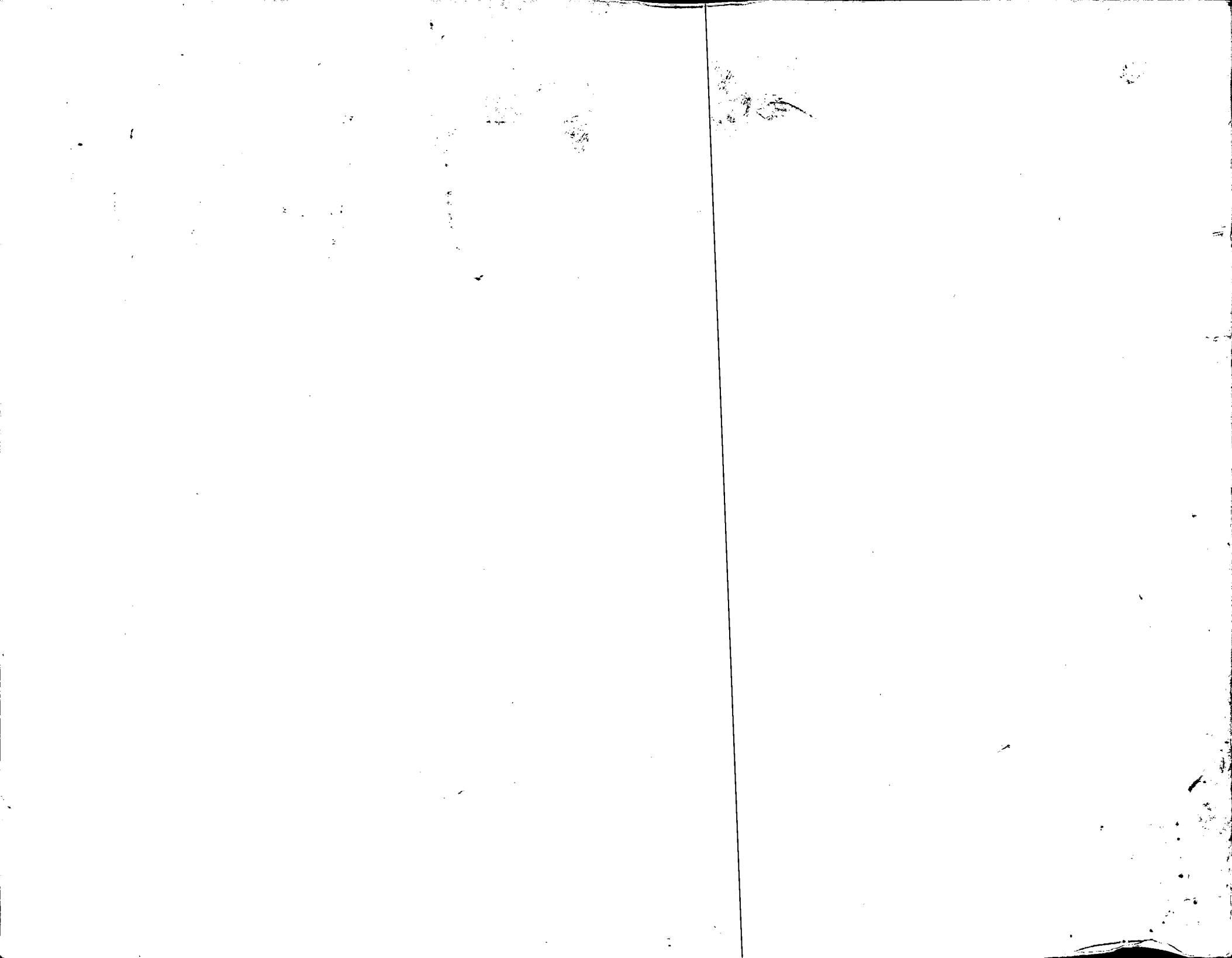


D2580-041 ASSEMBLY DETAIL



RELEASED  
98/09/17 DS

DESIGN D2580	DRAWN BY D2580	DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED D2580	APPROVED D2580	REV. C
DATE 98.08.26	TITLE 205 SKIDTUBE ASSEMBLY	SHEET 2 OF 2
		SCALE 1:24



NO. 80

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A205 634 041 / B 29469 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/11/29 Qualifier David Wood

